

**WHAT IS CLAIMED IS:**

1. Process for optimizing the adjustment of a deformation tool (12) provided for deformation of a sheet (10), thereby characterized, that the sheet (10) is preformed by means of a deformation tool (12) to be adjusted, subsequently for correction of the sheet geometry at least one partial area deformation (14) is introduced into the sheet (10) using a test tool (16) and, following attainment of the acceptable sheet geometry, the geometry of the partial area deformation (14) is used for adjusting the deformation geometry of the deformation tool (12).
2. Process according to Claim 1, thereby characterized, that the partial area deformation (14) is introduced in at least one edge area (18) of the preformed sheet (10).
3. Process according to Claim 2, thereby characterized, that the edge area (18) is a sheet edge (22) projecting essentially perpendicular to the main orientation plane (20) of the sheet (10).
4. Process according to one of the preceding claims, thereby characterized, that the partial area deformation (14) is introduced manually into the preformed sheet (10) using an auxiliary deformation tool (24).
5. Process according to Claim 4, thereby characterized, that the deformation geometry of the auxiliary deformation tool (24) is used for adjusting the deformation geometry of the deformation tool (12).

6. Process according to one of the preceding claims, thereby characterized, that the at least two partial area deformations (14) are introduced into the preformed sheet (10) simultaneously and/or timewise separate from each other.
7. Process according to one of the preceding claims, thereby characterized, that multiple geometrically distinct shaped partial area deformations (14) are introduced into the preformed sheet (10).
8. Process according to one of the preceding claims, thereby characterized, that the partial area deformation (14) is in the form at least one recess (26) in the open edge area.
9. Process according to one of the preceding claims, thereby characterized, that the sheet geometry changed by means of the partial area deformation (14) is checked using a sheet geometry acceptability test.
10. Process according to Claim 9, thereby characterized, that the sheet geometry acceptability test occurs using a testing device, in particular a shape gauge.
11. Process according to one of the preceding claims, thereby characterized, that the sheet (10) is sheet metal, in particular aluminum or an aluminum alloy.
12. Test tool for carrying out the process according to one of the preceding claims, thereby characterized, that the test tool (16) includes a carrier body (28) to which an adjustment element (30) for sheet deformation is secured

- slideably guided, and includes at least one deformation insert (32).
13. Test tool according to Claim 12, thereby characterized, that a respective, in particular exchangeable, deformation insert (32) is comprised of at least two insert parts (34) essentially complimentary in deformation geometry, wherein a first insert part (36) is secured to the adjustment element (30) and a second insert part (38) is secured to the carrier body (28).
  14. Test tool according to Claim 12 or 13, thereby characterized, that it includes a securing system (40) for a manually releasable securing of the insert part.
  15. Deformation tool, in particular for carrying out the process according to one of the preceding claims, thereby characterized, that the deformation tool (12) includes a stamp (42) and a die plate (44), wherein at least the stamp (42) includes at least one receptacle seat (46) for releasably securing a deformation tool insert part (48) for bringing about an associated partial area deformation (14) in the sheet (10).
  16. Deformation tool according to Claim 15, thereby characterized, that the stamp insert part (48), and in certain cases a die plate insert part, is securable in at least one edge area (52) of the deformation tool (12).
  17. Deformation tool according to Claim 15, thereby characterized, that the die plate (44) includes at least one deformation recess (50) embedded in the die plate (44)

and shaped essentially complimentary to the deformation geometry of an associated stamp insert part (48).